Work Orde April-11-13 2:3	er ID 99658		*996	358*						Page 1
Item ID: Revision ID: Item Name:	646.3910 Shim	/ T-77: 11: 12: 13: 13: 13: 14: 14: 14: 14: 14: 14: 14: 14: 14: 14	Accept	*N900	040	100)* s	etup Star Sto	I W	S1* S2*
Start Date: Required Date: Reference:	5/24/13 Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:					
Approvals:	Process Plan: MLゴ	Date: 13-04-1 6	Tooling:	D:	ate:		R	kun Sta	*N	R1*
	QC:				ate:			Sto	*N	R2*
Sequence ID/ Work Center I	Operation D Description	<u> </u>	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					,				
646.3900	N/C									
110			0.00							
110 Waterjet FLOW CNC Water	Memo jet Spring Sheete , Des Rev. Prog Rev.	er Dwg A/C	0.00				24	٥	<u></u>	JMB-4-1
71042 1010	riog icev.	<u>.,, c</u>								
	2-Deburr i	f necessary								
120	QC2- Inspect parts off	machine FAI/FAIB	0.00							
120							20	6		Jm13-4-19
QC	Memo		0.00							

Memo

Quality Control

NCR: Y	es / No				WORK ORDER NON-	CONFO	RMANCE / UP	DATE			
					T	<u> </u>	i was		QA Closed:	Date	:
Work Orde	r·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
WOIR Orac					Rework	7	Skid-tube	Crosstube		Water Jet	Engineering
Part N	0.				Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-				Use-as-is	The	rmoforming	Finishing	Rec/Sto	e/Packaging	Other
NCR N	o				Work Order Update]	Large Fab	Composite]	Supplier	
0	- 	Τ	·	Dasar	iption of work order update	Initia	Λ.	tion	Sign &		
Root	Date	Step	Qty	Descr	or Non-conformance	Chief E		cription	Date	Verification	QC Inspector
Cause Doc/Data	Date	step	Qty		of Non-comormance	Cillei Li	ig Desc	лрион	Date	Vermeation	Qe mspector
quip/Tooling											
Operator											
Material	=										
Setup			<u>.</u>								
Other	_										
Process											
Supplier				,							
Training		1									
Jnapproved											
	· · · · · · · · · · · · · · · · · · ·				F	AULT CA	TEGORY				
Landin	g Gear				General				_	_	_
	Bending				Bend	Grai	n		Ovalized		Pressure/Forced
	Centre No	ot Concei	ntric to	o/s	BOM/Route	Harc	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ection Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.		L	Burrs	Instr	uctions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mai	ntenance		Part Moved		
	Heat Trea	at			Countersink	Misl	abeled		Positioned \	Wrong _	_
	Inspectio	n Strip in	Tube		Cut Too Short	Misr			Power Loss,	'Surge	Other
	Ripples in	n Bend			Drill Holes	Offs	et				
	Torque W	Vaves in E	xtrusio	n [Drawing	Out	of Calibration				
	Turning S	Sequence			Finish	Out	of Sequence				
ſ	Wave/Tw	vist in Tul	e		Folio	Outs	ide Dimensions				

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		658		*9	9658	} *						Page 2
Item ID: Revision ID: Item Name:	646.3910 Shim			Accept	*/	1900	040	100)* s	etup Stai	i A	S1*
Start Date: Required Date: Reference:	5/24/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*			Cust Item I Customer:	D:					. 12
Approvals:	Process Pl	an:	Date:		:		ite:		ŀ	tun Sta Sto	1/1	R1* R2*
Sequence ID/ Work Center II 130 *120* QC Quality Control	D	Operation Description QC8- Inspect parts - secon	nd check	Set Up/ Run Ho 0.00	27 3 4 19	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*140 *140* Outsource3	- Cad plate	Outsource process-Cadpla Memo Issue P/O:		0.00						_pl/	13-04 <u>-</u> 1	9
150		Receive & Inspect for Dat	mage & Mat'l Certs	0.00					/	131	10/21	6)

0.00

Memo

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Packaging

Packaging

			DQA:	_Date: _	
ICR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

										QA Closed:	Date):	
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part I	No				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fal Thermoforming Finishin Large Fab Composite			⊣	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Work order						-		raige rab	composite		Jupplier		
Root				Descri	iption of work order update	Ini	tial	Act	tion	Sign &	`		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desci	ription	Date	Verification	QC Inspector	
Doc/Data			İ										
Equip/Tooling													
Operator				,									
Material													
Setup		İ											
Other					•								
Process													
Supplier													
Training													
Unapproved			<u> </u>			<u> </u>					<u> </u>		
					· · · · · · · · · · · · · · · · · · ·	AULT	CATE	GORY	· · · · · · · · · · · · · · · · · · ·	,			
Landi	ng Gear			_	General				r	7	_		
•	Bendin	-			Bend	\vdash	rain		į_	Ovalized	-	Pressure/Forced	
		Not Conce	ntric to	o/s	BOM/Route		ardwa		ļ	Over/Under	⊢	Temperature/Cure	
	Cracks			<u> </u>	Broken/Damaged *	├	-	ion Incomplete	_	Part Incorre	· -	Weld	
		d/Crimped		<u> </u>	Burrs	 		ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs		•	<u> </u>	Contamination			enance	<u> </u>	Part Moved			
	Heat Tr			-	Countersink	\mathbf{H}	1islabe		<u> </u>	Positioned V			
		ion Strip in	Tube	ļ	Cut Too Short	-	1isread	d .	L	Power Loss/	Surge	Other	
	——————————————————————————————————————	in Bend	<i>.</i>		Drill Holes	\vdash	ffset	e 19 - 49					
	_	Waves in		n	Drawing			Calibration					
		s Sequence		<u> </u>	Finish	\vdash		Sequence					
	IWave/	wist in Tu	be		lFolio	1 10	utside	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord April-11-13 2:.		0658		*99	հ58 *	•							Page	3
Item ID: Revision ID: Item Name:	646.3910 Shim			Accept	*N9	300	040	100)*	Setup	Start Stop	*N *N	S1* S2*	:
Start Date: Required Date Reference:	5/24/13 :: 5/24/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*			st Item I stomer:	D:							
Approvals:	Process Pl	an:	Date:	Tooling:		Da	ate:	*		Run	Start	1/1	R1*	
••			Date:			Da	ate:				Stop	*N	R2*	
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours,		ool ID	Tool #	Plan Code	Accep Qty	t Re Qt	•	Reject Number	Insp. Stamp	
160		QC5- Inspect part comple	eteness to step on W/O	0.00	1				\mathcal{N}		i			
160 QC Quality Control		Memo		0.00 135	· 33				W		.1			
			:									f	otic 2 (2	
170		Identify as per dwg & Sto	ock Location:	0.00					n/1 /	1		, ,	(1)
170 Packaging				0.00	•	57536			The		13	/05/2	2 2	2)
Packaging		Memo ***IDENTII REV***	FY AS PER APICAL MPP		THE P# AND						,	·		
180		QC21- Final Inspection -	Work Order Release	0.00						ļ	2/2	</td <td>7</td> <td>1</td>	7	1

0.00

Memo

180

Quality Control

1315/2140 MF 13-65~JA

NCR:	(es)/ No	6	tigh	3	WORK ORDER NO	N-COI	NFORN	ΛANCE / U	JPDATE	DQA:(QA Closed:	Date:	
Work Orde	er: E	. 99	65	X	DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part N	No. 6	46.	39 H41	10	Rework Scrap Use-as-is Work Order Update	14	Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	Data	Ston	Otv		ption of work order update or Non-conformance	1	nitial iief Eng		Action	Sign & Date	Verification	QC Inspector
Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	BS21	Step	Qty)	tour	1 1 1 100	-10 (AS 160 100 100 100 100 100 100 100 100 100	Dostro	escription and apple so of 4.00	13S 21	(SISTIN	DAS 16 2-042 (3/1st2)
					(, 0	FAUL	T CATE	GORY /	· · · · · · · · · · · · · · · · · · ·	/		
Landi	Bending Centre N Cracks Crushed, Cuffs Heat Tre Inspection Ripples in Torque V	/Crimped at on Strip in n Bend Vaves in I	Tube Extrusion		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of O	on Incompleto ions Incomple enance eled	 	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Wave/Tv	vist in Tul	be		Folio		Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1

Work Order ID:

99658

Parent Item:

646.3910

Parent Item Name:

Shim

Start Date: 5/24/13

Required Date: 5/24/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV:A 12.12.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.020 C1095 Blue Tempered Spr	ing Steel Sheet .020	Purchased	No			110	sf	8.4000	0.03	0.631 57 8 7.0			Jm13-4-19
				Location		Los Otro	1 .	o Codo					

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-	CONF	ORN	MANCE / UPDATE	(QA Closed:	Date	•
Mark Orda					DISPOSITION			AGAINST		ARTMENT		
Work Orde	r:				Rework	¬		Skid-tube Crosstube	\Box		Water Jet	Engineering
Part N	lo				Scrap	- - - 	N	Machining Small Fab	,		d. Eng. Coor.	Quality Other
NCR N	lo.				Use-as-is Work Order Update	┪		Large Fab Composite	·	Nec/stor	Supplier	- Other
Root				Descri	ption of work order update	Initi	ial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Description		Date	Verification	QC Inspector
ooc/Data quip/Tooling Operator Material Setup Other Process Supplier Fraining Unapproved												
Jiiappioveu	<u> </u>	1	<u> </u>	L		FAULT C	:ATE(GORY			<u> </u>	
Landir	ng Gear				General							
	Bending Centre N Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples ir	Crimped at in Strip in in Bend Vaves in E	Tube Extrusio		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Ha Ins Ins Mi Mi Ofi	ainte ainte islabe isread fset ut of C	on Incomplete ions Incomplete/Unclear enance eled d		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Turning S	Sequence		1	Finish	Ou	it of S	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	_99658
Description: Shim	Part Number:	646.3910
Inspection Dwg: 646.3900 Rev: N/C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST											
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments					
1.57	+/-0.005	1.574"	_		V	Jemoi					
2.90	+/-0.005	2.894			U						
0.020	+/-0.005	0.030,			J						
					?						
			OAG								
!	Jm	Audited by:	27		Preliminary A						
Date:	3-4-19	Date:	1347	ا لــــــــــــــــــــــــــــــــــــ		Date:					
v Date (Change New Issue				Revise KJ	ed by Approved					

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NOTES 1.11 MATERIAL: SHIM STOCK, C 1095 BLUE-TEMPERED SPRING STEEL Start Care NOOL TREE OF COPY FINISH: CAD PLATE PER QQ-P-416 TYP II CL2 TREE LINES OF THE PROPERTY 3. IDENTIFY IAW MPP-120 100 000 99658 NO 2.90 -.020 13-04-16 2.90 .020 1.57 1.00 R.13 4PL - R.13 4PL 646.3912 646.3910 -- 2.90 --.032 2.90 - .032 1.57 1.00 R.13 4PL R.13 4PL 646.3911 646.3913 SHBM 646.3913 646.3912 SHIM 646.3911 SHIM 646.3910 FIND# PART# DESCRIPTION QTY PARTS LIST APICAL INDUSTRIES
2608 TEAPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300 SHIM B 07MZ6
SCALE NONE 646.3900



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19639

Purchase Order Date 4/19/2013 PO Print Date 4/23/2013

Page Number 1 of 1

Order From:

VC-CAD002

CADORATH COATING 2150 LOGAN AVE. WINNIPEG, MB R2R 0J2 CA

Contact Name

Vendor Phone

204 633 9420

Vendor Fax

204 633 8033

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr

Net 30

Currency

CAD

10127-2607

FOB

Terms

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA



Line Nbr Reference Revision ID Vendor Part Numbe	Description/ Mfg ID	Req Date/ Taxable Ún	Req Qty/ it of Measure	Ship Method	Unit Price	Extended Price
1 99658	646.3910 Shim	5/3/2013 Yes	21.00	FedEx PI collect	\$7.1900	\$150.99
	Special Inst:	Finish: Cad Plate po Type II CL2	er QQ-P-416			
2 99775	646.3911 Shim	5/3/2013 Yes	12.00	FedEx PI collect	\$7.1900	\$86.28
	Special Inst:	Finish: Cad Plate po	er QQ-P-416			

Type II CL2

PO Total:

\$237.27



No substitution or deviation without consent. Certificate of Conformity of Material Certification required - YE\$ NO

CERTIFICATE OF CONFORMANCE

CADORATH PLATING CO. LTD. 2150 LOGAN AVENUE WINNIPEG, MANITOBA R2J-0J1

DATE:

May-16-2013

CONSIGNED TO: Dart Aerospace Ltd.

1270 Aberdeen St.

W/O #:

124245

Hawksbury, ON K6A 1K7

INVOICE #:

66018

CONTRACT OR

PURCHASE ORDER #

PO19639

DESCRIPTION:

SHIM

QTY

21

P/N# 646-3910

S/N # 99658

CADMIUM PLATING IAW AMS-QQ-P-416C TYPE 2 YELLOW CLASS 2. BAKE HEAT CHART # 13-437 AND # 13-447.

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.

Approved Inspector:



Packing Slip

ShipTo:



Sold To:
Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

Cadorath Coating

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2 **Phone:** (204) 633-9420 **Fax:** (204) 633-8033

INVOICE NUMBER:

S66018

Net 2% Interest Per Month charged on Overdue Accounts. Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

_		DateReceived:	Terms:	G.S.T. #:	Ship Via:	Ship Date:
/ PO	19639	Apr-23-2013	NET 30 DAYS	10071 6547 RT0001		May-16-2013
Item # 'Qty	P/AV-8: Di	escription				
1 2	LEA SHIM		S/N	99658		
	P/N 646.39	10	W/O	124245		
2 12	EA SHIM		S/N	99775		
	P/N 646.39	11	W/O	124246		